

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020900**Date Inspected:** 19-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

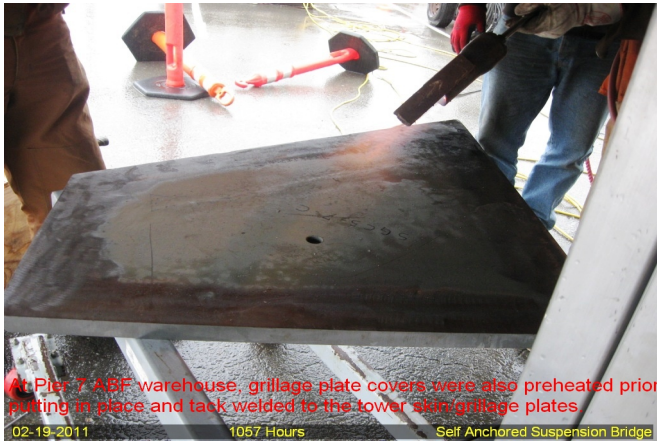
At Pier 7 ABF warehouse, this QA performed random observation on the fit up and tack welding of the cover plate made on SAS Tower Grillage South Shaft. The ABF welder Rick Clayborn was observed performing tack welding on the one inch thick cover plate with various dimensions to the 90mm tower skin plates and 70mm grillage plates. The welder was noted tack welding in 4F (overhead) position utilizing 1/8" diameter E9018H4R electrode implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-F026-4. The paint coating on the cover plates and the skin/grillage plates were ground removed and the plates were preheated to more than 225 degrees Fahrenheit prior welding. During tack welding, ABF QC Mike Johnson was noted monitoring the welding parameters of the welder. QA performed parameter check during welding with 130 amperes noted reading using the digital clamp meter which deemed in compliance to the approved WPS. At the end of the shift, the following south shaft grillage cover plates were tack welded;

1. S-GC5-21C – tack welded
2. S-GC5-7C – tack welded
3. S-GC5-6B – tack welded
4. S-GC5-1A – tack welded
5. S-GC5-1B – tack welded
6. S-GC5-2A – tack welded

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

7. S-GC5-3E – put in place



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Lizardo, Joselito
----------------------	-------------------

Quality Assurance Inspector

Reviewed By:	Levell, Bill
---------------------	--------------

QA Reviewer
